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**Request for grant of a patent**

(See the notes on the back of this form. You can also get an explanatory leaflet from the Patent Office to help this form))

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1. Your reference	P.73285 PEJ		
2. Patent application number (The Patent Office will fill in this part)	15 JUL 1997	9714880.3	
3. Full name, address and postcode of the or of each applicant (underline all surnames)	RHÔNE-POULENC CHEMICALS LIMITED Oak House, Reeds Crescent, Watford, Hertfordshire WD1 1QH		
Patents ADP number (if you know it)	British body corporate	5573019002	
If the applicant is a corporate body, give the country/state of its incorporation		5573019002	
4. Title of the invention	REFRIGERANT COMPOSITIONS		
5. Name of your agent (if you have one)	J A KEMP & CO		
"Address for service" in the United Kingdom to which all correspondence should be sent (including the postcode)	14 SOUTH SQUARE GRAY'S INN LONDON WC1R 5LX		
Patents ADP number (if you know it)	26051		
6. If you are declaring priority from one or more earlier patent applications, give the country and the date of filing of the or of each of these earlier applications and (if you know it) the or each application number	Country	Priority application number (if you know it)	Date of filing (day / month / year)
7. If this application is divided or otherwise derived from an earlier UK application, give the number and the filing date of the earlier application	Number of earlier application	Date of filing (day / month / year)	
8. Is a statement of inventorship and of right to grant of a patent required in support of this request? (Answer "Yes" if: a) any applicant named in part 3 is not an inventor, or b) there is an inventor who is not named as an applicant, or c) any named applicant is a corporate body: See note (d))			

## REFRIGERANT COMPOSITIONS

The present invention relates to refrigerant compositions, particularly for use as replacements in refrigeration equipment currently employing, or designed to employ, the refrigerants R12 and R22.

Refrigerant R12 ( $\text{CCl}_2\text{F}_2$ ) has been a commonly used refrigerant especially in domestic refrigerators. However, R12 contains chlorine atoms and has been implicated in environmental damage to the ozone layer. As a result efforts have been made to replace R12 with a refrigerant formulation which does not involve the use of refrigerants such as R12 which contain chlorine atoms. Similar comments apply to R22 which is used principally for air conditioning systems.

Among alternatives, particular attention has been directed at R134a ( $\text{C}_2\text{H}_2\text{F}_4$ ) along with pentafluoroethane (R125) (b.pt.  $-48.6^\circ\text{C}$ ). Commercial formulations of these two refrigerants involve the use of a hydrocarbon, namely propane, propylene or isobutane. While these refrigerant formulations are generally effective as replacements for R12 and R22, nevertheless it has been found that their use is not entirely satisfactory.

Difficulty has arisen with the flammability of the fractionated composition, that is to say the vapour above the liquid composition possesses flammability problems. As a result these commercial formulations can produce flammable compositions under some leak scenario conditions. The flammability of these refrigerant compositions resides in their hydrocarbon content. One of the purposes of incorporating the hydrocarbon is so that formulation is compatible with the lubricants ordinarily used in R12 and R22 refrigeration equipment. The specific hydrocarbons have been selected because they possess the correct boiling point in relation to that of the fluorocarbon.

It has now been found, surprisingly, according to the present invention, that if a hydrocarbon with at least 4 carbon atoms other than methyl propane (isobutane) is used instead of those previously advocated the flammability of the fractionated composition is greatly reduced. This result is very surprising as n-butane, for example, has a significantly higher boiling point ( $-0.5^{\circ}$ ) than, say, isobutane ( $-11.7^{\circ}\text{C}$ ) and is accordingly less volatile. Further, although there can be a considerable boiling point range between the lowest boiling point component and the hydrocarbon of the composition the temperature glide of the blend is relatively small. In a particular embodiment, although the boiling point range is  $36.2^{\circ}\text{C}$ , the temperature glide is only 3.9K at the boiling point of  $-34.6^{\circ}\text{C}$  at one atmosphere pressure. It is further surprising that such a formulation has a reduced flammability because n-butane, for example, has a larger range of flammability limits as compared with isobutane. Thus n-butane has a flammability range from 1.5 to 10.1% v/v whereas for isobutane it is only 1.7 to 9.7% v/v.

According to the present invention there is provided a refrigerant composition which comprises

- (a) R125, R218 (octafluoropropane; b.pt.  $-36.7^{\circ}\text{C}$ ), trifluoromethoxy-difluoromethane (b.pt.  $-34.6^{\circ}\text{C}$ ) or hexafluoro-cyclopropane (b.pt.  $-31.5^{\circ}\text{C}$ ), or a mixture of two or more thereof, in an amount from 5 to 60% by weight based on the weight of the composition
- (b) R125, R134a, R134, 1,1-difluoroethane (R152a; b.pt.  $-24.7^{\circ}\text{C}$ ), trifluoromethoxypentafluoroethane (b.pt.  $-23.3^{\circ}\text{C}$ ), 1,1,1,2,3,3,3-heptafluoropropane (R227ea; b.pt.  $-18.3^{\circ}\text{C}$ ) or 1,1,1,2,2,3,3-heptafluoropropane (R227ca; b.pt.  $-16.3^{\circ}\text{C}$ ), or a mixture of two or more thereof, in an amount from 30 to 94% by weight based on the weight of the composition and
- (c) an unsubstituted hydrocarbon of the formula  $\text{C}_n\text{H}_m$  in which n is at least 4 and m is at least  $2n-2$ , other than methyl propane, in an amount from 1 to 10% by weight based on the weight of the composition.

Component (c) will be present in amount from 1 to 10%, especially 1 to 8%, preferably 2 to 6% and more preferably 2 to 5%, by weight of the composition.

It will be appreciated that component (a) and component (b) can both be R125. In this situation the composition can, therefore, be binary and the amount of R125 will be from 90 to 99% by weight. In all other situations, the composition will be at least ternary.

Among the preferred compositions of the present invention are those which contain one of more of R125, R134a and R218. Thus component (a) preferably comprises R125 and/or R218 while component (b) preferably comprises R125 and/or R134a.

The presence of R218 (b.pt -36.7°C) is particularly useful where the only other fluorocarbon is R134a. In such circumstances R218 is particularly present in an amount from 5 to 20% by weight, especially 5 to 15%, and more preferably 7 to 12% by weight of the composition.

Component (a) is present in an amount from 5 to 60% by weight, generally 5 to 50% by weight. If R125 does not form part of component (a) then the amount will typically be from 5 to 20%, especially 5 to 15% and preferably 7 to 12%, by weight. It will be appreciated that if the composition contains R125, the concentration of R125 can be split between components (a) and (b).

The concentration of component (b) is from 30 to 94% by weight, generally 50 to 90% and especially 75 to 90%, by weight.

Typically hydrocarbons which can be employed as component (c) possess 4 or 5 carbon atoms and include methylenecyclopropane, 1-butene, cis and trans-2-butene, butane, cyclobutane, cyclopentene, cyclopentane, 2-methyl-1-butene, 2-methyl-2-butene, 3-methyl-1-butene, 1-pentene, cis and trans-2-pentene, 2-methylbutane, pentane and mixtures of two or more thereof. The use of n-butane is particularly preferred.

Specific formulations which have been found to be effective are as follows:

	<u>% by weight</u>		<u>% by weight</u>
R218	9	R125	46
R134a	88		50
n-butane	3		4

The following Examples further illustrate the present invention; Examples 2,3 and 5 are included for comparison.

Worst case fractionation study:

The apparatus used for these determinations consisted of a small stainless steel cylinder (343 cm<sup>3</sup> internal volume) which was charged with the blend under evaluation in various fill ratios and was then placed in a temperature controlled bath brought to the appropriate temperature and allowed to equilibrate for at least 30 minutes. The temperature in the bath was controlled to within 0.1°C and was monitored with a platinum resistance thermometer. Once equilibrated a 75 cm<sup>3</sup> sample cylinder was attached to the test cylinder using quick connections and the void spaces between the test cylinder and the sample cylinder evacuated with a vacuum pump. The system was left for at least 15 minutes to check for leaks and then vapour from the test cylinder was slowly introduced into the sample cylinder using a metering valve. Once the pressure in the sample cylinder reached 1 atmosphere the introduction was stopped, the two cylinders isolated and then the sample cylinder was removed for analysis by GLC. The GLC was calibrated using three separate analyses of a standard which were made up in such a way as to be quite close to the vapour composition expected for the test mixture. This sampling was repeated and a duplicate sample analysed on the GLC. This was repeated at various temperatures with various fill ratios and the worst case result was the one with the highest hydrocarbon content.

The results obtained as shown below. The flammability tests, determined using the method detailed in ASTM E 681-85, show that the formulations of Examples 1 and 4 are significantly superior to those of Examples 2, 3 and 5, while possessing good refrigeration performance.

	Liquid Composition % w/w				
	R125	R218	R134a	R600a	R600
Example 1	46	-	50	-	4
Example 2	46	-	50	4	-
Example 3	46.5	-	50	3.5	-
Example 4	-	9	88	-	3
Example 5	-	9	88	3	-

#### Refrigeration Performance as an alternative to R22

Evaporator Temperature / °C	Refrigeration Effect / kW				Coefficient of Performance			
	R22	Example 1	Example 2	Example 3	R22	Example 1	Example 2	Example 3
-15	0.932	0.855	0.823	0.711	1.269	1.204	1.194	0.966
-10	1.328	1.124	1.133	1.058	1.492	1.443	1.436	1.323
-5	1.723	1.437	1.476	1.413	1.716	1.700	1.695	1.624
0	2.118	1.796	1.852	1.775	1.939	1.976	1.970	1.869
5	2.513	2.200	2.262	2.145	2.163	2.270	2.262	2.058

#### Refrigeration Performance as an alternative to R12

Evaporator Temperature / °C	Refrigeration Effect / kW			Coefficient of Performance		
	R12	Example 4	Example 5	R12	Example 4	Example 5
-15	0.585	0.706	0.738	0.942	1.002	1.036
-10	0.786	0.877	0.889	1.227	1.312	1.314
-5	1.018	1.119	1.128	1.513	1.623	1.591
0	1.281	1.434	1.453	1.799	1.933	1.869
5	1.575	1.820	1.865	2.085	2.244	2.146

#### Fractionation and Flammability test results

Blend	Fractionated Vapour Composition / % w/w					Lower Flammable Limit % v/v in Air
	R125	R218	R134a	R600a	R600	
Example 1	60.7	-	34.6	-	4.7	Non Flammable
Example 2	64.4	-	29.1	6.5	-	12
Example 3	64.7	-	29.8	5.5	-	15
Example 4	-	22.9	72.5	-	4.6	Non Flammable
Example 5	-	21.5	72.5	6	-	9

